



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 76223

Monday, November 07, 2011 2:43:16 PM

\*76223\*

Page 2

Item ID: D3407-041

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Item Name: Tow Ring

Stop

\*NS2\*

Start Date: 11/7/2011 Start Qty: 10.00

\*10\*

Cust Item ID:

Required Date: 11/16/2011 Req'd Qty: 10.00

\*10\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

130

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

\*130\*

Powdercoat

Powder Coating

Memo

\*\*Mask Threaded Section\*\*

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

10-10 0F  
400  
10-40

140

QC3- Inspect Part Finish

0.00

\*140\*

QC

Quality Control

Memo

0.00

150

Identify as per dwg & Stock Location:

463

0.00

\*150\*

Packaging

Memo

0.00

15XAM-11/12/19

15-XM-11/12/19  
COMPLETED

11/12/19 JG (5)

W/O:		WORK ORDER CHANGES					
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**Work Order ID 76223**

Monday, November 07, 2011 2:43:16 PM

**\*76223\***

Page 3

**Item ID:** D3407-041

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

**Revision ID:**

**Item Name:** Tow Ring

Stop

**\*NS2\***

**Start Date:** 11/7/2011 **Start Qty:** 10.00

**\*10\***

**Cust Item ID:**

**Required Date:** 11/16/2011 **Req'd Qty:** 10.00

**\*10\***

**Customer:**

**Reference:**

**Approvals:**

**Process Plan:**

**Date:**

**Tooling:**

**Date:**

Run Start

**\*NR1\***

**QC:**

**Date:**

**SPC (Y/N):**

**Date:**

Stop

**\*NR2\***

**Sequence ID/  
Work Center ID**

**Operation  
Description**

**Set Up/  
Run Hours**

**Tool ID**

**Tool #**

**Plan  
Code**

**Accept  
Qty**

**Reject  
Qty**

**Reject  
Number**

**Insp.  
Stamp**

160

QC21- Final Inspection - Work Order Release

0.00

**\*160\***

QC

Quality Control

Memo

0.00

MF  
11-12-19

MF  
11-12-19

W/O:		WORK ORDER CHANGES							
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NOTE: Date & initial all entries

# Picklist Print

Monday, November 07, 2011 2:43:20 PM

Page 1

Work Order ID: 76223

\*76223\*

Parent Item: D3407-041

\*D3407-041\*

Parent Item Name: Tow Ring

Start Date: 11/7/2011

Required Date: 11/16/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A05.10.14New issueKJ/EC

IPP Rev:B 08-09-09 revE as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3407-1	*D3407-1*	Manufactured	No	76996X1		100	Each	0.0000	1	10		11-12-13	
Stem		76996X1							**				
D3407-5	*D3407-5*	Manufactured	No	76024X4		100	Each	15.0000	1	10		11-12-13	
		76024X4							**				
Location				Loc Qty			Loc Code						
WA				15									
74155				8									
74881				7									

W/O:		WORK ORDER CHANGES						
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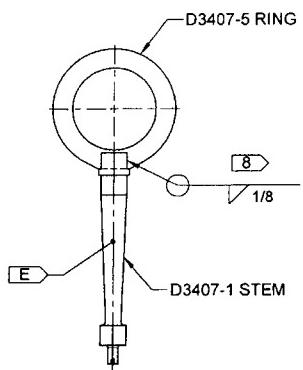
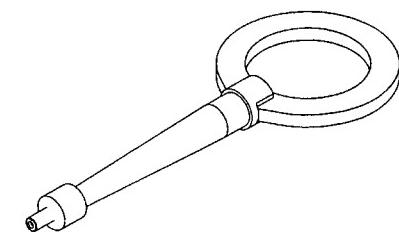
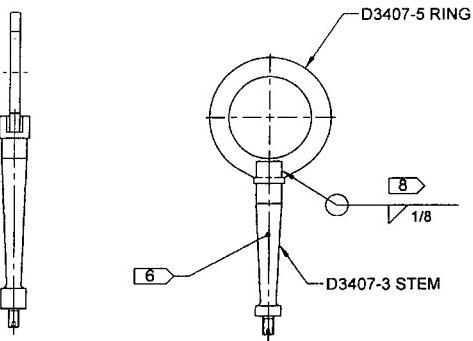
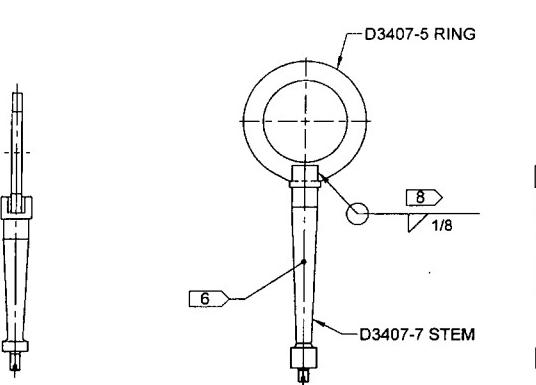
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

E

QTY -041	QTY -043	QTY -045	PART NUMBER	DESCRIPTION
X			D3407-041	TOW RING
	X		D3407-043	TOW RING
		X	D3407-045	TOW RING
1			D3407-1	STEM
	1		D3407-3	STEM
1	1	1	D3407-5	RING
		1	D3407-7	STEM

D3407-041 TOW RINGD3407-043 TOW RINGD3407-045 TOW RINGRELEASED  
*08-08-2018*

A

## NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3 (EXCEPT THREADS)
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3407-XXX" USING BLACK FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D3407-041 - 0.60 lbs, D3407-043 - 0.53 lbs, D3407-045 - 0.61 lbs
- 8) WELD PER DART QSI 004 ON ALL EDGES BETWEEN STEM AND RING

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. W223

*07/11/07*

E

E	ADD D3407-045 (ZN B2-1, D8-1); ADD D3407-7 (ZN B6-5); REVISED NOTE 6 TO ADD IDENTIFICATION (ZN A5-1); REASON: PRODUCTION FACILITY	PH	08.07.23
D	D3407-1/3 SLOT WAS ROUND NOW FLAT FOR ASSEMBLY WITH D3407-5 (ZN B2-1); D3407-7 WAS ROUND NOW FLAT ON ONE END FOR ASSEMBLY WITH D3407-1/3 (ZN B6-4); REASON: PRODUCTION FACILITY	PH	08.04.07
C	-1/3 LONGER FOR FIT W/WASHER	CP	05.09.09
B	UPDATE DIAMETER, THREAD CLASS ADDED	CP	05.06.17
A	NEW ISSUE	CP	05.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>IP</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	<i>IP</i>		
CHECKED	<i>A</i>		
MFG. APPR.	<i>IP</i>		
APPROVED	<i>IP</i>		
DE APPR.	<i>IP</i>		
DRAWING NO.	D3407	REV. E	
		SHEET 1 OF 5	
TITLE	TOW RING		
SCALE	NTS		
DATE	08.07.23		

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8 7 6 5 4 3 2 1

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C

B

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

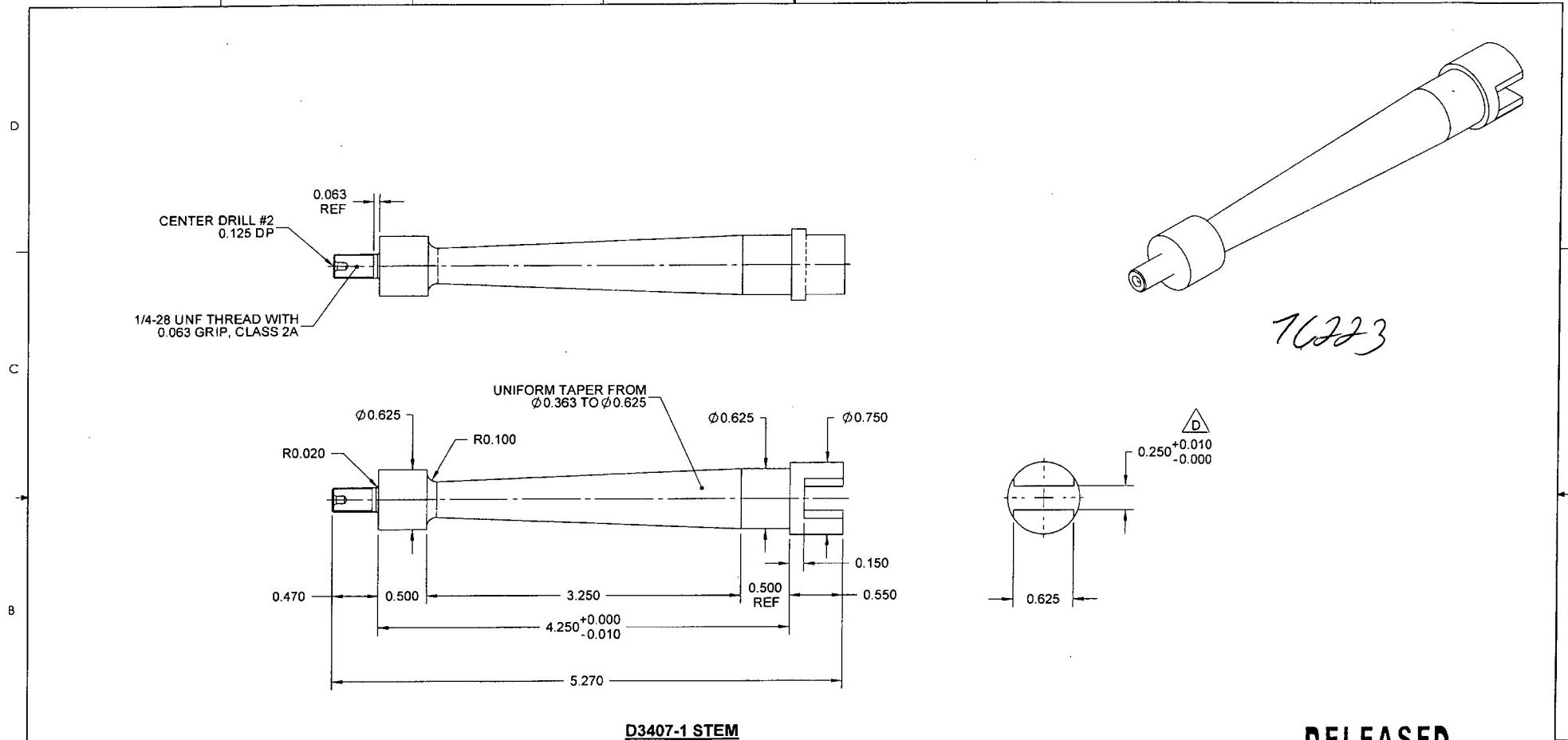
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



**NOTES:**

- 1) MATERIAL: 17-4 PH SS ROUND BAR PER AMS 5643 (REF. DART SPEC M17-4-R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.33 lbs

7/22/23

RELEASED  
06-07-21 NY

DESIGN	P	DART AEROSPACE USA, INC.	
DRAWN	AP	PORT HADLOCK, WA	
CHECKED		DRAWING NO. D3407	
MFG. APPR.		REV. E	
APPROVED		SHEET 2 OF 5	
DE APPR.		TITLE TOW RING	
DATE 08.07.23		SCALE NTS	
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8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
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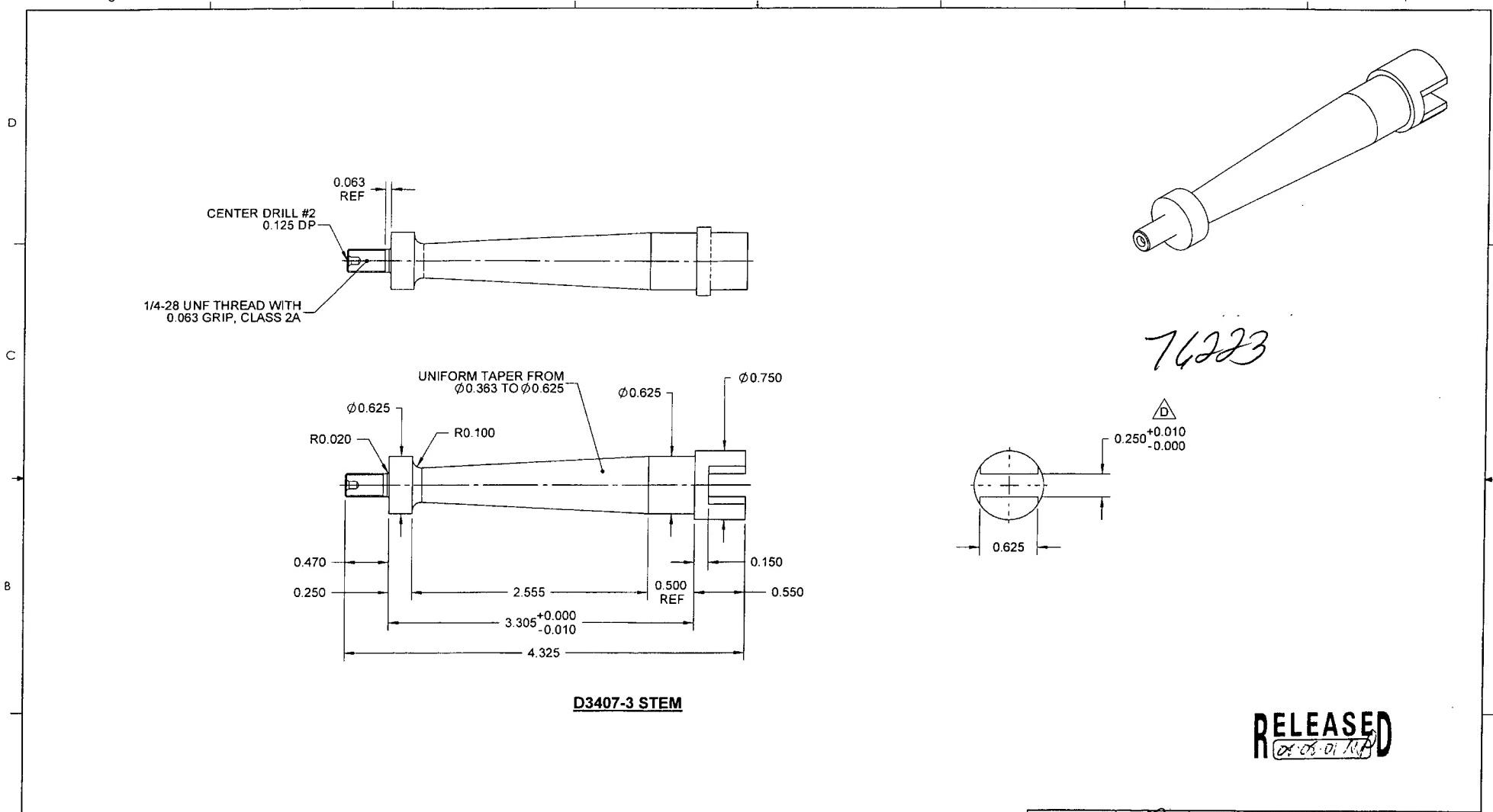
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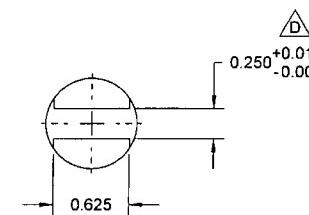
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



- NOTES:**
- 1) MATERIAL: 17-4 PH SS ROUND BAR PER AMS 5643 (REF. DART SPEC M17-4-R)
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.27 lbs



**RELEASED**  
*[Signature]*

DESIGN	<i>[Signature]</i>	<b>DART AEROSPACE USA, INC.</b>
DRAWN	<i>[Signature]</i>	PORT HADLOCK, WA
CHECKED	<i>[Signature]</i>	DRAWING NO. <b>D3407</b> REV. E
MFG. APPR.	<i>[Signature]</i>	SHEET 3 OF 5
APPROVED	<i>[Signature]</i>	TITLE <b>TOW RING</b>
DE APPR.	<i>[Signature]</i>	SCALE <b>NTS</b>
DATE	<b>08.07.23</b>	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

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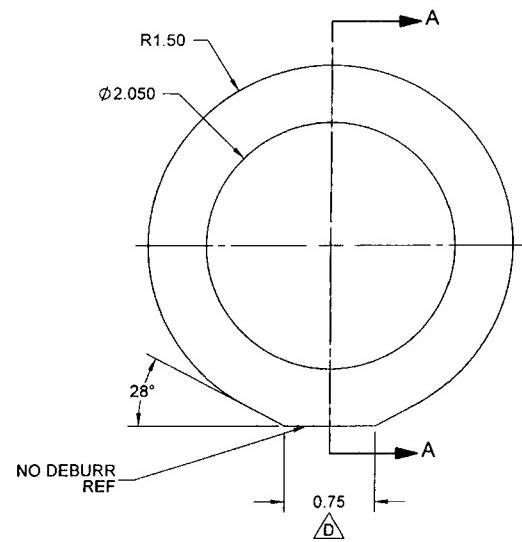
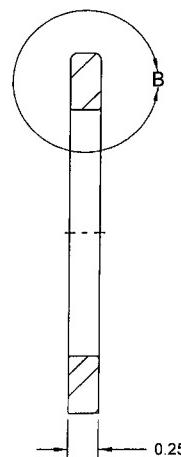
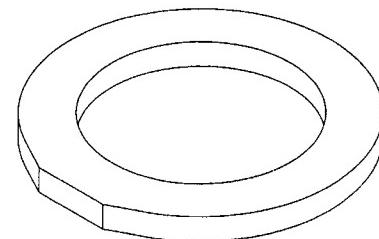
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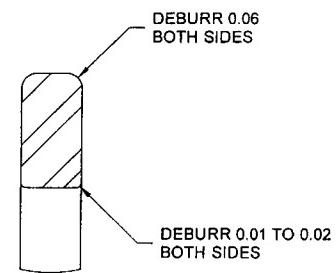
8 7 6 5 4 3 2 1

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D

D3407-5 RINGSECTION A-A

7/6/23



**DETAIL B**  
SCALE 2X

**RELEASED**  
*[Signature]*

A

A

**NOTES:**

- 1) MATERIAL: 17-4 PH SS BAR PER AMS 5604/5643 (REF. DART SPEC M17-4-B)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.27 lbs

8 7 6 5 4 3 2 1

DESIGN	<i>[Signature]</i>	<b>DART AEROSPACE USA, INC.</b>
DRAWN	<i>[Signature]</i>	PORT HADLOCK, WA
CHECKED	<i>[Signature]</i>	DRAWING NO. REV. E
MFG. APPR.	<i>[Signature]</i>	D3407 SHEET 4 OF 5
APPROVED	<i>[Signature]</i>	TITLE SCALE
DE APPR.	<i>[Signature]</i>	TOW RING NTS
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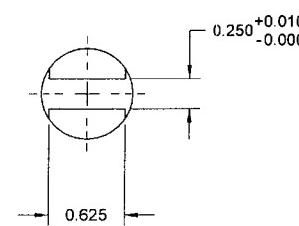
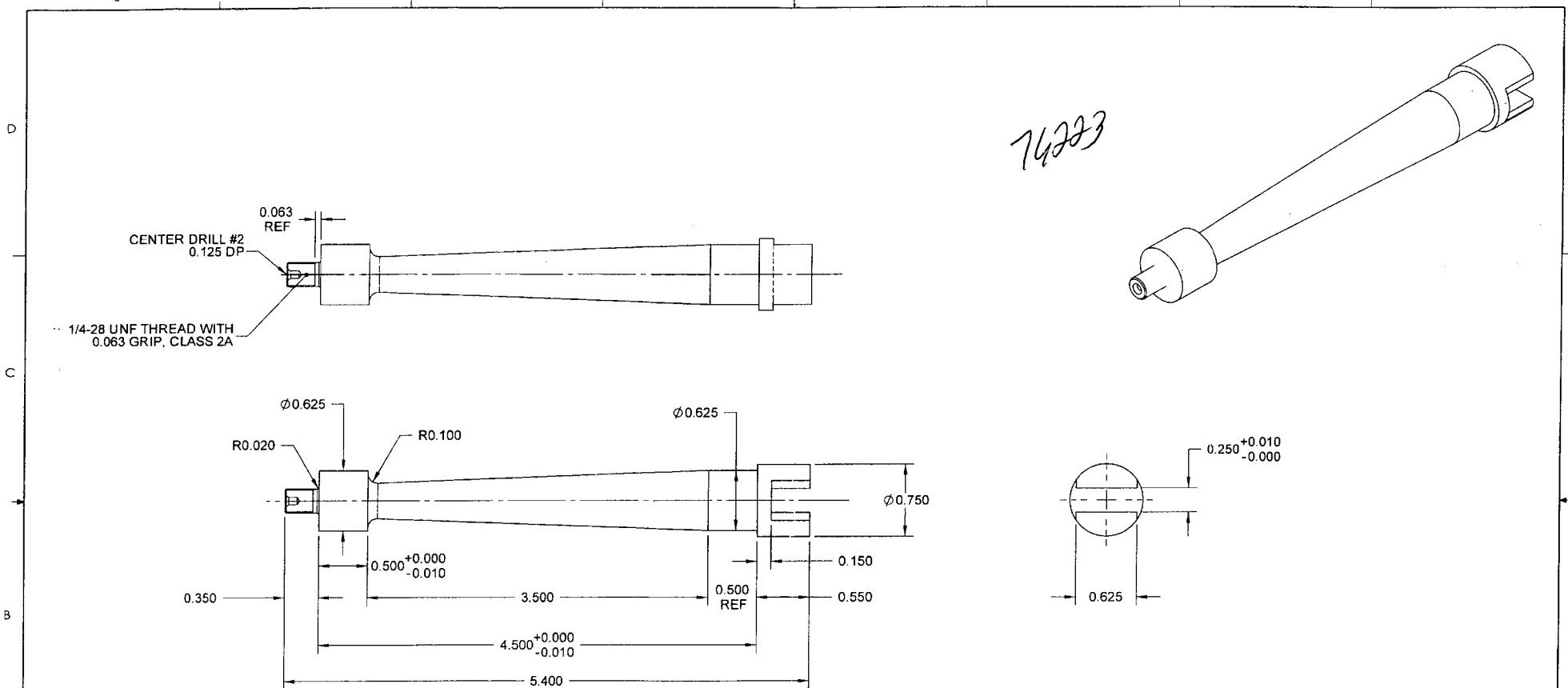
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8 7 6 5 4 3 2 1



RELEASED  
06-09-01 MP

- NOTES:**
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  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.34 lbs

DESIGN	AJS	DART AEROSPACE USA, INC.
DRAWN	<i>[Signature]</i>	PORT HADLOCK, WA
CHECKED	<i>[Signature]</i>	DRAWING NO. REV. E
MFG. APPR.	<i>[Signature]</i>	D3407 SHEET 5 OF 5
APPROVED	<i>[Signature]</i>	TITLE
DE APPR.	<i>[Signature]</i>	SCALE
DATE	08.07.23	NTS

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8 7 6 5 4 3 2 1

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